



Dart Aerospace Ltd.
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K6A 1K7
Canada

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RBW6405G08732-3G

Job Sheet 201239



Part No: RBW6405G08732-3G

Job Qty: 1 pcs

Part Name: Tail Rotor Bushing Removal Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/27/19

Job Tracking No:

Due Date: 9/27/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG RBW6405G08732-3G REV F SHEET 2 IPP Rev.A 17.09.01 New issue DP Verify DD IPP Rev B17.11.14
Rev B DP Verify DD/IPP Rev. C 19.03.29 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	9/27/19	9/27/19	0.00	0.20	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	9/27/19	9/27/19	0.00	0.00	QC 5 - 10		SEP 27 2019 40 8-88
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	9/27/19	9/27/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		



Container No: S218020



Part: RBW6405G08732 - 3G

Job No: 201239

Serial No/Batch: S218020

Revision: F

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Date: 09/27/19

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					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	ML
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

140 QC 21 - SA	1 pcs	9/27/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 SEP 30 2019
				QC 21 - SA - 53	9-89

Part Op 110 - Assemble as per drawing					
Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)					
130 - (Identify as per dwg & Stock Location:_____)					
140 - (QC21- Final Inspection - Work Order Release)					

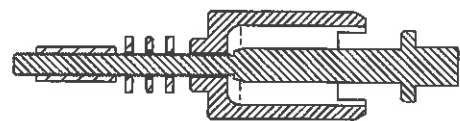
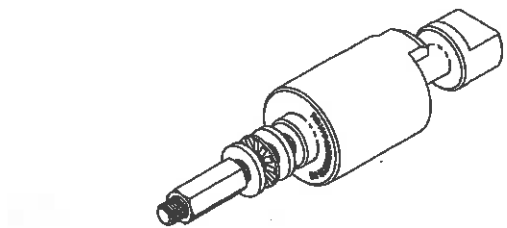
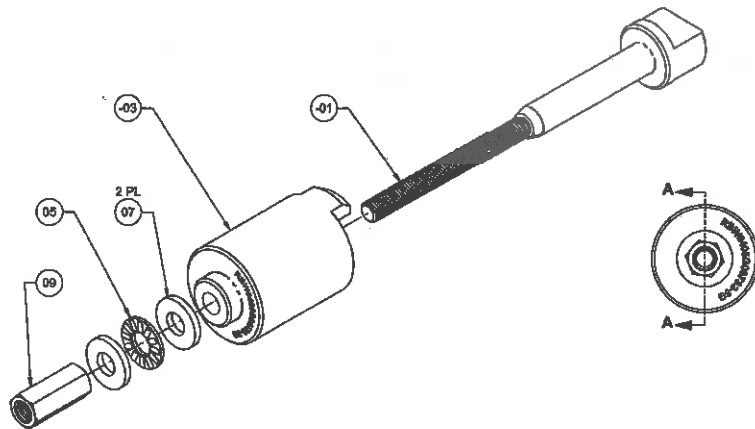
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
90264A440	Zinc Plate Steel Coupling Nut 1/4"-28	1 Ea (1 ea)	110-Small Fab - 1	516988
NTA-411	Bearing	1 Ea (1 ea)	110-Small Fab - 1	5033972
RBW6405G08732-3G-01	Extractor Rod	1 pcs (1 ea)	110-Small Fab - 1	5015143
RBW6405G08732-3G-03	Receiver	1 pcs (1 ea)	110-Small Fab - 1	5014895
TRC-411	Thrust Washer 1/4" ID	2 Ea (2 ea)	110-Small Fab - 1	5070541

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	90264A440	1	11	0
	NTA-411	1	32	0
	RBW6405G08732-3G-01	1	1	0
	RBW6405G08732-3G-03	1	1	0
	TRC-411	2	14	0

Part Specifications
Specifications could not be found.

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ITEM #	QTY	PART #	PART TITLE
-01	1	RBW8405G08732-3G-01	EXTRACTOR ROD
-03	1	RBW8405G08732-3G-03	RECEIVER
05	1	NTA-411 OR EQUIV	THRUST BEARING 1/4" ID
07	2	TRC-411 OR EQUIV	THRUST WASHER 1/4" ID.
09	1	McMaster90284A440 OR EQUIV	ZINC PLATE STEEL COUPLING NUT 1/4"-28



SECTION A-A

RBW8405G08732-3G T/R BUSHING REMOVAL TOOL

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 1"$
XJOK = $\pm 0.01"$ / $\pm 0.5"$
XJOKK = $\pm 0.005"$ / $\pm 0.1"$
XJOKKK = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

SEE PREVIOUS PDF FOR OLDER REV TEMPLATE AND NOTES UPDATED ITEM 09 WAS MISCOMPLIANT IS McMaster90284A440 ITEM -03 FINISH WAS CLEAR ANODIZE IS RED ANODIZE, ENGRAVING MODIFIED, MATERIAL WAS 7075 IS 8081/7075, ENGRAVING MODIFIED, DIMENSIONS CHANGED ITEM -01 MATERIAL WAS 4140/4142 Q&T IS 4140 (28-32 Rc), FINISH WAS ZINC PLATE IS BLACK OXIDE, ENGRAVING REMOVED, THREAD RELIEF ADDED, 10.0MM MAX ADDED, NOTES ADDED ITEM 05 AND 07 DESCRIPTION UPDATED		19-587	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
DRAWN	VM		
CHECKED	VM		
MFG. APPR.	FK		
APPROVED	VM		
DATE 2/14/2019			

DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
TOOL PART # RBW8405G08732-3G	REV F
TITLE T/R BUSHING REMOVAL TOOL	SHEET 1 OF 3
SCALE	NTS
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